

Date: Friday, 7/4/2008 12:48:40 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
Job Number : 40280	
Estimate Number : 10832	
P.O. Number :	Part Number : D29322
This Issue : 7/4/2008 S.O. No. :	Drawing Number : D2932 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 39180	Material :
Written By :	Due Date : 7/30/2008 Qty: 10 Um: Each
Checked & Approved By : <u>08 04 07</u>	
Comment : Est: B 00:06:26 New DWG rev (mpp 2069) EC	
Est Rev: C As per Rev C 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	Saddle Billet, 7075
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0 x 6.25 X 7.88

Grain Along Long 7.88 Length

Batch No: B34873

08/08/22 10

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr

08/08/24 (10)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

08/08/25 (10)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

08/08/25 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 12:48:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 40280

Part Number: D29322

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08/08/25

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

n2/m-p 08/08/26

7.0

POWDER COATING

POWDER COATING



M108523



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:00
01-
320
8:30

M-1 08/08/26

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-08-26 (X10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 428

8/8/26

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26

Job Completion



W 08/08/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40280
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.115	.116	.125	.124		
B	0.100	0.140		.114	.115	.125	.126		
C	0.100	0.140		.105	.105	.124	.124		
D	0.210	0.230		.230	.230	.225	.225		
E	1.245	1.255		1.249	1.250	1.250	1.250		
F	1.245	1.255		1.249	1.250	1.250	1.250		
G	2.495	2.505		2.498	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.576	1.576	1.576	1.576		
J	2.495	2.505		2.497	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.314	.316	.316	.316		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.122	.123	.120	.120		
O	0.540	0.560		.549	.551	.550	.550		
P	0.490	0.510		.500	.500	.500	.501		
Q	3.715	3.725		3.719	3.720	3.720	3.720		
R	2.470	2.510		2.493	2.493	2.493	2.493		
S	0.240	0.270		.259	.259	.252	.253		
T	0.100	0.180		.136	.136	.139	.139		
U	1.625	1.635		1.628	1.628	1.620	1.620		
V	1.362	1.372		1.366	1.367	1.367	1.367		
W	0.316	0.321		.317	.317	.317	.317		
X	1.125	1.145		1.137	1.138	1.138	1.139		
Y	1.565	1.585		1.570	1.578	1.570	1.574		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>MR / SA</i>
Date: 08/08/24

Audited by: <i>JL</i>
Date: 08/08/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	40280
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.125	.125"	.128"	.128"		
B	0.100	0.140		.124	.125"	.128"	.128"		
C	0.100	0.140		.124	.120"	.125"	.125"		
D	0.210	0.230		.225	.226"	.223"	.225"		
E	1.245	1.255		1.256	1.250"	1.250"	1.250"		
F	1.245	1.255		1.250	1.251"	1.251"	1.251"		
G	2.495	2.505		2.495	2.501"	2.501"	2.501"		
H	0.510	0.515		.510"	.510"	.510"	.510"		
I	1.572	1.582		1.577	1.579"	1.579"	1.579"		
J	2.495	2.505		2.500	2.500"	2.500"	2.500"		
K	0.257	0.262		.259	Ø.258"	Ø.258"	Ø.258"		
L	0.312	0.317		.317	Ø.313"	Ø.313"	Ø.313"		
M	0.235	0.240		.237"	.237"	.237"	.237"		
N	0.100	0.140		.139	.122"	.119"	.121"		
O	0.540	0.560		.548	.545"	.547"	.547"		
P	0.490	0.510		.501	.501"	.503"	.502"		
Q	3.715	3.725		3.720	3.718"	3.718"	3.718"		
R	2.470	2.510		2.453	2.493"	2.493"	2.493"		
S	0.240	0.270		.253	.252"	.258"	.258"		
T	0.100	0.180		.140	.140"	.140"	.140"		
U	1.625	1.635		1.620	1.629"	1.629"	1.629"		
V	1.362	1.372		1.368	1.368"	1.368"	1.368"		
W	0.316	0.321		.317	Ø.316"	Ø.316"	Ø.316"		
X	1.125	1.145		1.138	1.139"	1.139"	1.133"		
Y	1.565	1.585		1.572	1.573"	1.567"	1.573"		
Z	0.178	0.198		.188	R.188"	R.188"	R.188"		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>SN J.F.</u>
Date: <u>08/08/24</u>

Audited by: <u>JL</u>
Date: <u>08/08/29</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD				Work Order: 40280	
Description: 206 Saddle, Inboard, Left side				Part Number: D2933-2	
Inspection Dwg: D2933 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

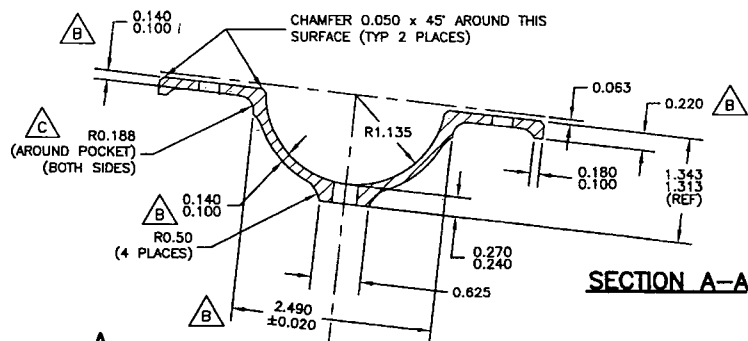
☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.128"	.128"			
B	0.100	0.140		.128"	.128"			
C	0.100	0.140		.125"	.125"			
D	0.210	0.230		.223"	.223"			
E	1.245	1.255		1.250"	1.250"			
F	1.245	1.255		1.251"	1.251"			
G	2.495	2.505		2.501"	2.501"			
H	0.510	0.515		.510"	.510"			
I	1.572	1.582		1.579"	1.579"			
J	2.495	2.505		2.500"	2.500"			
K	0.257	0.262		Ø .258"	Ø .258"			
L	0.312	0.317		Ø .313"	Ø .313"			
M	0.235	0.240		.237"	.237"			
N	0.100	0.140		.118"	.119"			
O	0.540	0.560		.548"	.548"			
P	0.490	0.510		.503"	.504"			
Q	3.715	3.725		3.718"	3.718"			
R	2.470	2.510		2.493"	2.493"			
S	0.240	0.270		.258"	.257"			
T	0.100	0.180		.140"	.140"			
U	1.625	1.635		1.629"	1.629"			
V	1.362	1.372		1.368"	1.368"			
W	0.316	0.321		Ø .316"	Ø .316"			
X	1.125	1.145		1.130"	1.131"			
Y	1.565	1.585		1.569"	1.571"			
Z	0.178	0.198		A.188"	B.188"			
AA								
AB								
AC								
AD								
AE								

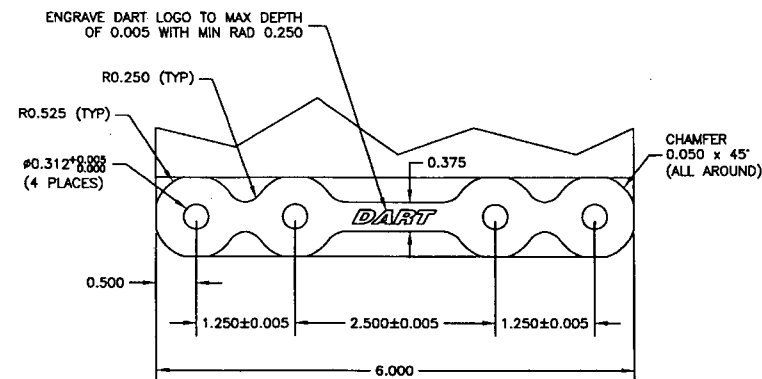
Accept/Reject

Measured by: J.F. 08/08/24	Date: 08/08/29
Audited by: JL	Date: 08/08/29
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	



SECTION A-A

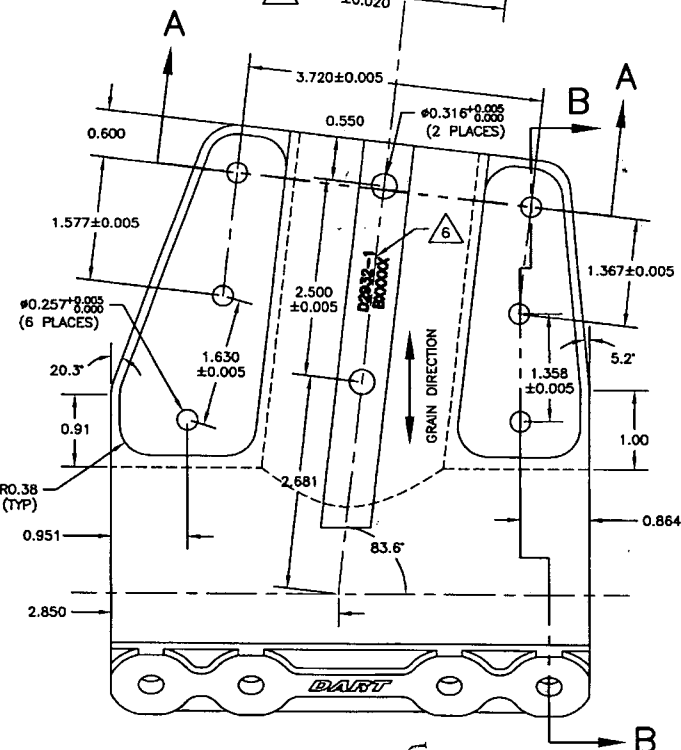


VIEW C-C

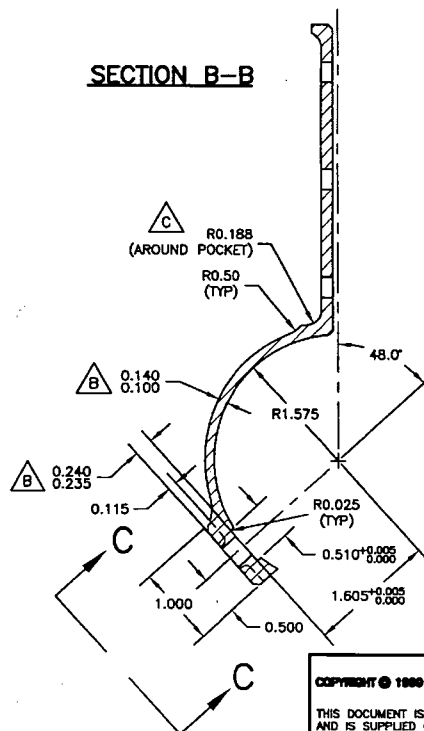
D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	BY <i>CB</i>	DRAWN BY <i>CB</i>
CHECKED	BY <i>PH</i>	APPROVED <i>PH</i>
DATE	06.11.09	
TITLE	SADDLE OUTSIDE	
REV. C		
SHEET 1 OF 1		
SCALE		2:3

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DART DART AEROSPACE USA, INC.
BELLEVUE, WA

DRAWING NO. D2932

TITLE SADDLE OUTSIDE

SCALE 2:3

RELEASED

07-02-02

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